



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.3011

Job Sheet 180125



Part No: 646.3011

Job Qty: 12 ea

Part Name: RH Half



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/29/18

Job Tracking No:

Due Date: 7/27/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV N/C SHEETS 2,6,7 IPP REV:A NEW ISSUE 13/01/14 JFS VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	12 Ea		7/27/18	0.00	0.00	Start Up Machining-1		<i>mw</i>
100	Bandsaw	12 pcs		7/27/18	0.00	0.13	Bandsaw1		<i>mw</i>
110	CNC Vertical Machining	12 pcs		7/27/18	0.18	9.60	HAAS1-1		<i>mw</i>
120	QC	12 pcs		7/27/18	0.00	0.00	QC1		
130	QC	12 pcs		7/27/18	0.00	0.00	QC8 Machining-1		<i>mw 18/9/15</i>
140	Outsource	12 pcs		7/27/18			ATG001-VC	5	<i>SEP 18-21 18</i>
150	Packaging	12 pcs		7/27/18	0.00	0.00	Packaging2		<i>SEP 17 2018</i>
155	QC	12 pcs		7/27/18	0.00	0.00	QC5		<i>SEP 17 2018</i>
180	Packaging	12 pcs		7/27/18	0.00	0.00	Packaging3-1		<i>9-89</i>
190	QC21-SA	12 Ea		7/27/18	0.00	0.00	QC21		<i>SEP 22 2018</i>

Part Op 100 - Cut Blank at 9.700"

Descriptions: 110 - 1-Machine per folio FB158

120 - Inspect on CMM as per folio CMMA029.

140 - Issue P/O to ATG : *P0040939* Hard Black Anodize, Color Black and Prime as Per Dwg 646.3000

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S6.000X0.250 <i>12R 3094000</i>	7075-T6S Sheet 6" Thick Plate X 0.25" Wide	9.7080 ft (.809 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S6.000X0.250	10	25	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	RH Half	0.250inches $\pm$ 0.005	0.255 0.245		
2	RH Half	0.109inches $\pm$ 0.005	0.114 0.104		
3	RH Half	0.200inches $\pm$ 0.005	0.205 0.195		
4	RH Half	0.050inches $\pm$ 0.005	0.055 0.045		
5	RH Half	9.536inches $\pm$ 0.005	9.541 9.531		
6	RH Half	0.209inches + 0.005 - 0.001	0.214 0.208	Diameter	
7	RH Half	0.177inches + 0.005 - 0.001	0.182 0.176	Diameter	
8	RH Half	0.250inches $\pm$ 0.005	0.255 0.245		
9	RH Half	0.625inches $\pm$ 0.005	0.630 0.620		

Plex 6/29/18 7:59 AM dart.lacelle.linda



Container No: S107568



Part: 646.3011

Job No: 180125

Serial No/Batch: S107568

Revision:

Inspector:

Exp Date:

Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/02/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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DART AEROSPACE LTD	Work Order:	180125
Description: RH Half	Part Number:	646.3011
Inspection Dwg: 646.3000 Rev: NC1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <i>M.N.</i>	Audited by:	Preliminary Approval:
Date: <i>2018/09/01</i>	Date:	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.25	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040939**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040939
PO Date: 9/6/18
Due Date: 9/24/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178575	RBT400213-4	Right Clamp -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	9/24/18	20 pcs	0 pcs	20 pcs	\$8.10/pcs	\$162.00
							20 X	SEP 17 2018			
2	180125	646.3011	RH Half Issue P/O to ATG : Hard Black Anodize, Color Black and Prime as Per Dwg 646.3000	Firmed	-	9/24/18	12 pcs	0 pcs	12 pcs	\$14.60/pcs	\$175.20
							12 X	SEP 17 2018			
3	178574	RBT400213-3	Left Clamp -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	9/24/18	20 pcs	0 pcs	20 pcs	\$8.10/pcs	\$162.00
							20 X	SEP 17 2018			
Grand Total:											\$499.20

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/6/18 10:44 AM dart.tsimiklis.chrisoula

CT.



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916042

Date: 17-Sep-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Haw' esbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
12 ea	Part: 646.3011 RH Half Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23681	Rev: NC	PO: PO040939 Line: 2
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>17/09/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			